



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4931-1

Job Sheet 194703



Part No: D4931-1

Job Qty: 12 pcs

Part Name: Engine Fitting (for acft models B2 & previous)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/7/19

Job Tracking No:

Due Date: 6/14/19

Created By: Jennifer Renwick

Type: SOLD

Description:

Note: DWG REV A SHEET 1 IPP REV:A NEW ISSUE 13-09-05 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Stop-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Doosan - 1	12 pcs	6/14/19	6/14/19	0.00	15.00	Doosan - 1		 DAS 5 9-89
110	QC 2	12 pcs	6/14/19	6/14/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		DAS 5
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		DAS 5
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		DAS 5
							QC 2 - 5		
							QC 2 - 71		
							QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
120	QC 8	12 pcs	6/14/19	6/14/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		

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Container No: S184060



Part: D4931-1

Job No: 194703

Serial No/Batch: S184060

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 05/26/19

				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
130	Packaging 3-2 - Stock - B4B 12 pcs	6/14/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140	QC 21 - SA 12 pcs	6/14/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	
Part Op 100 - (Doosan Lathe) Machine as per folio FB210 Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB) 120 - QC8- Inspect parts - second check) 130 - Identify as per dwg & Stock Location: _____)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M303R2.000	303 Round Bar 2"	3 ft (.25 ea)	100-Doosan - 1	5166566	1618
				5163533	477
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Doosan - 1	M303R2.000	3	25	0	

Part Specifications	
Specifications could not be found.	

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DART AEROSPACE LTD		Work Order: 194703
Description: EAPS P2 Engine Fitting		Part Number: D4931-1
Inspection Dwg: D4931	Rev: A	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.06 x 45°	+/-0.030 x +/-0.5°	.05745°			Caliper	
0.362	+/-0.010	.365				
0.088	+/-0.010	.087				
0.08	+/-0.030	.075				
0.25	+/-0.030	.252				
0.50	+/-0.030	.500				
Ø0.063	+0.004/-0.001	.064				
0.125	+/-0.010	.128				
0.424	+/-0.010	.430				
0.315	+/-0.010	.308				
0.185	+/-0.010	.184				
37°	+/-0.5°	37°				
1.283	+/-0.010	1.283				
1.250	+/-0.010	1.251				
Ø0.472	+0.006/-0.001	.476				
Ø0.670	+0.008/-0.001	.670				
0.500	+/-0.010	.498				
0.950	+/-0.010	.948				
Ø0.609	+0.008/-0.001	.612				
2X 0.938	+0.000/-0.005	.936				
1.804 Ref	+/-0.010	1.812				
1-1/16-12 UN 2A	N/A	OK			NOT AN 8/8	
M18 x 1.5 Thread	N/A	OK			GO/NOGO	
Wire Size 0.55	Max 1.099 ⁵ Min 1.093 ⁸	1.096			Micrometer	
Wire Size 0.040	Max 0.737 ⁸ Min 0.732 ³	.734				

Measured by: DC	Checked by: amf	QC Inspector:
Date: 19/05/06	Date: 19/06/05	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.08.27	New Issue	KJ	
B	16.05.30	Dimensions updated	KJ	